

Work Order ID 68358

Tuesday, April 12, 2011 10:11:11 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: 11-04-12 Date: 11-04-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

304 . 640

11-4-19

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

11-4-19

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11-4-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68358

Tuesday, April 12, 2011 10:11:12 AM



Page 2

Item ID:	D3535-15	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	4/12/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	4/15/2011	Req'd Qty: 6.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 joggle as per Dwg D3535 using Jig DT8158	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 10:10 FINISH TIME: 10:40	0.00							

SB 11/04/19

=> m-d 11/04/20

8 11/04/20

7 BL 11-4-26

W/O:		WORK ORDER CHANGES					
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Work Order ID 68358

Tuesday, April 12, 2011 10:11:12 AM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 0 11/04/21

170

Identify as per dwg & Stock Location *FP18*

0.00



Packaging

Memo

0.00

Packaging

7 11-4-25

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25

11-04-25
(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:11:18 AM

Page 1

Work Order ID: 68358

Parent Item: D3535-15

Parent Item Name: Wearshoe





Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	67.4000	1.0205	6.445263	7.2		
												KB11-4-19	

Location

Loc Qty

Loc Code

MAT020

67.4

116437

25.4

116623

42

116623



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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48358
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	>		V 1802	
2.000	+/-0.010	2.000	=		V	
5.650	+/-0.010	5.656	>		T 1801	
9.150	+/-0.010	9.150	=		T	
14.400	+/-0.010	14.400	=		T	
19.650	+/-0.010	19.625	<		T	
24.900	+/-0.010	24.900	=		T	
30.150	+/-0.010	30.156	>		T	
33.650	+/-0.010	33.650	=		T	
35.650	+/-0.010	35.656	>		T	
39.150	+/-0.010	39.150	=		T	
Ø0.188	+0.005/-0.001	.191	>		V	
24.00	+/-0.030	24.00	=		T	
16.00	+/-0.030	16.00	=		T	
8.00	+/-0.030	8.00	=		T	
5.00	+/-0.030	5.00	=		T	
0.300	+/-0.010	.302	>		J	
0.300	+/-0.010	.305	>		V	
0.038	+/-0.010	.035	<		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-4-19	Date: 11/6/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	B

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DART

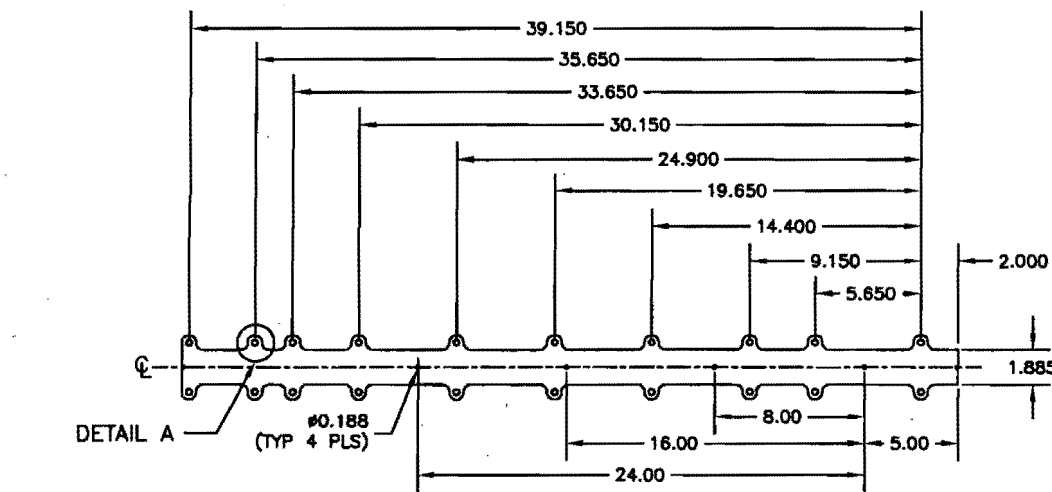
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07.04.17

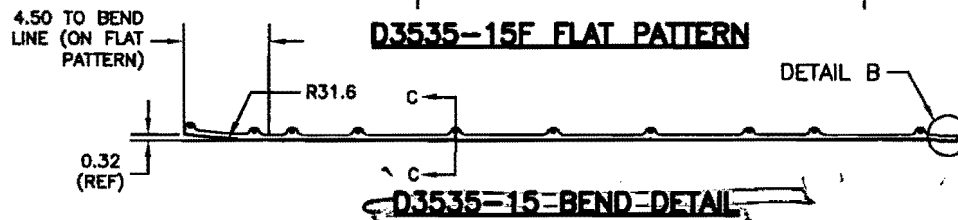
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7
	SCALE 1:10	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 18358

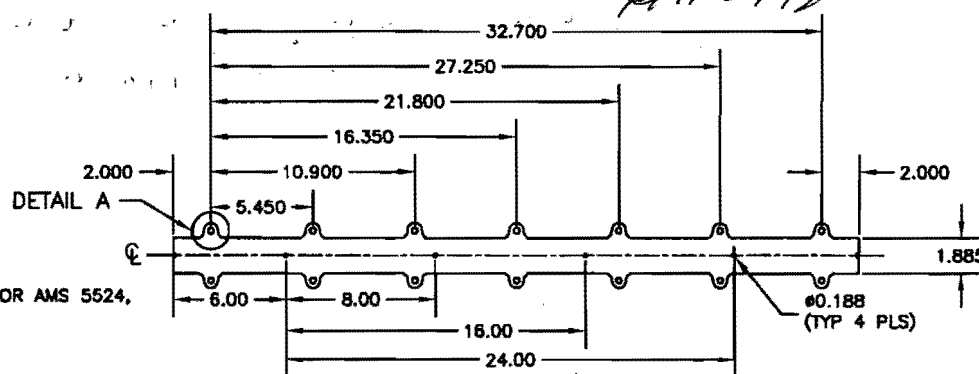
PH 11-04-12



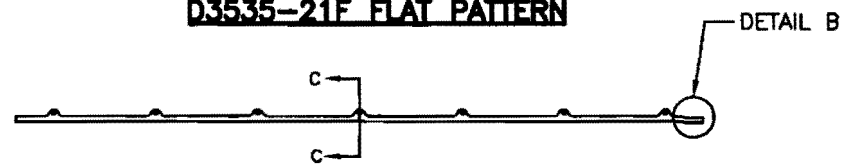
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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